

# (12) UK Patent Application (19) GB (11) 2 353 499 (13) A

(43) Date of A Publication 28.02.2001

(21) Application No 0018992.8

(22) Date of Filing 02.08.2000

(30) Priority Data

(31) 09379946 (32) 24.08.1999 (33) US

(71) Applicant(s)

Hewlett-Packard Company  
(Incorporated in USA - Delaware)  
3000 Hanover Street, Palo Alto, California 94304,  
United States of America

(72) Inventor(s)

Melissa D Boyd  
Mark E Gorzynski  
Timothy E Beerling  
Evan P Smouse  
Kenneth Royston Williams

(74) Agent and/or Address for Service

Carpmaels & Ransford  
43 Bloomsbury Square, LONDON, WC1A 2RA,  
United Kingdom

(51) INT CL<sup>7</sup>

B41J 2/15

(52) UK CL (Edition S )

B6F FLM

(56) Documents Cited

EP 0481829 A2 US 5764254 A US 5598191 A  
US 5075689 A US 4215350 A

(58) Field of Search

UK CL (Edition R ) B6F FLM  
INT CL<sup>7</sup> B41J 2/145 2/15  
Online:EPODOC,PAJ,WPI

(54) Abstract Title

**Ink jet print head with varied nozzle spacing for producing a seamless swath of printing**

(57) An ink jet print head 10 includes an array 12 (Fig.1) of nozzles 14 (Fig.1) arranged along an axis 16. The array has a first portion 22 in which the nozzles are spaced apart along the array axis by a first pitch, and a second portion 24 in which the nozzles are spaced apart by a different second pitch. The array may have a third portion 20 (Fig.1) between the first and second portions with a third pitch different from the first and second pitches. An assembly 30 (Fig.2) may include two or more of the print heads 10, with the second portion 24 of one head overlapping with the first portion 22 of the other head. The assembly may be operated by determining a best aligned pair of nozzles (72,83, Fig.5A), disabling the nozzles (73-75,84,85) extending beyond each member of the pair, and disabling one of the pair to prevent double printing of a single dot row, before printing therewith. The assembly ensures a seamless swath of printing.

FIG. 1

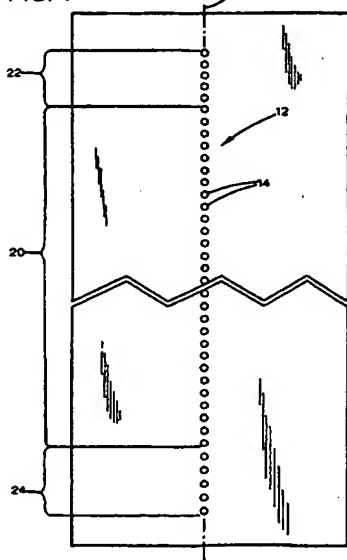
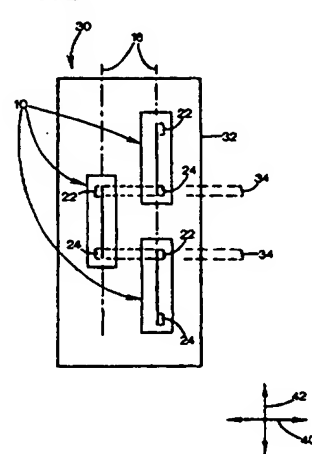


FIG. 2



GB 2 353 499

1/4

FIG. 1

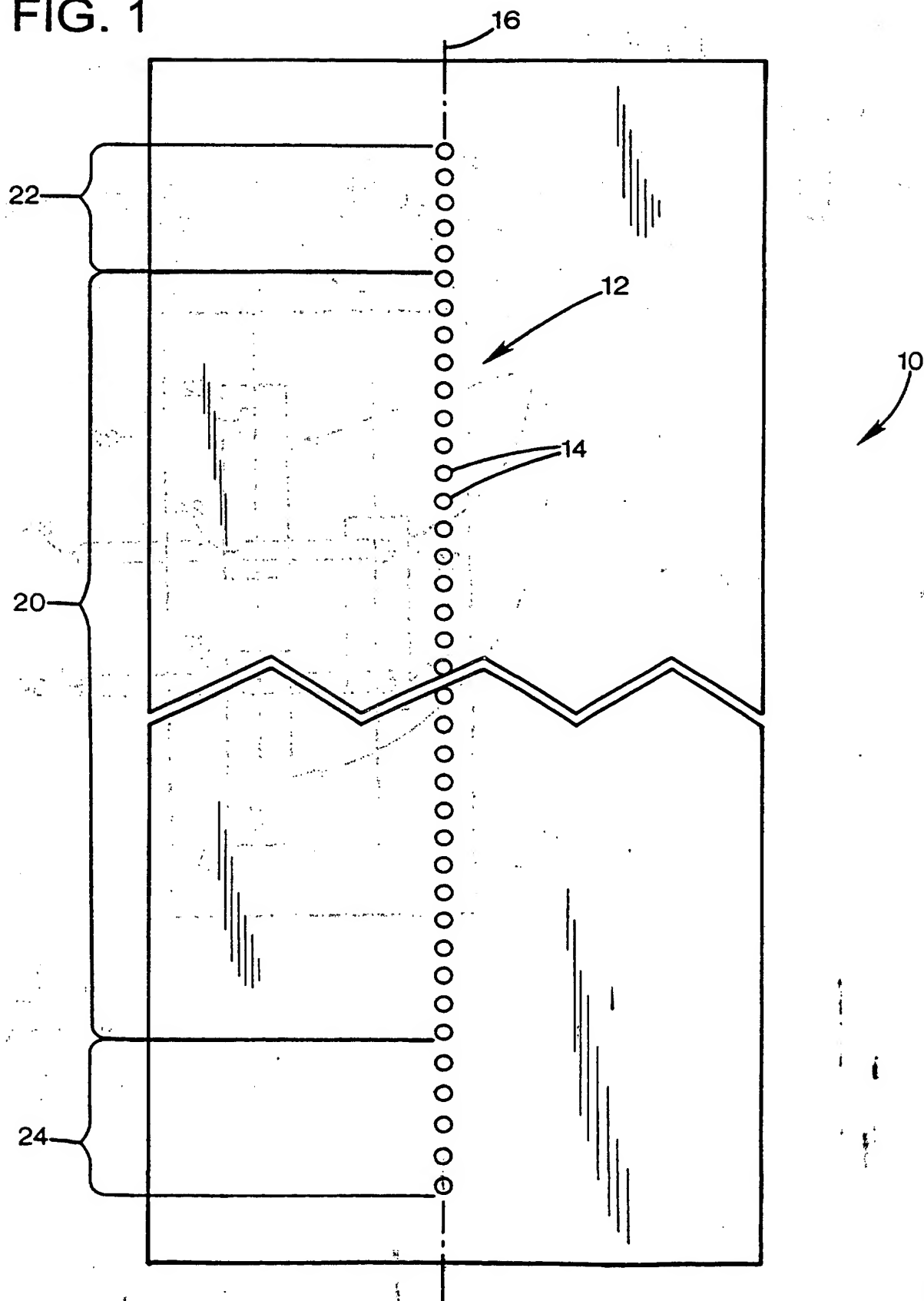


FIG. 2

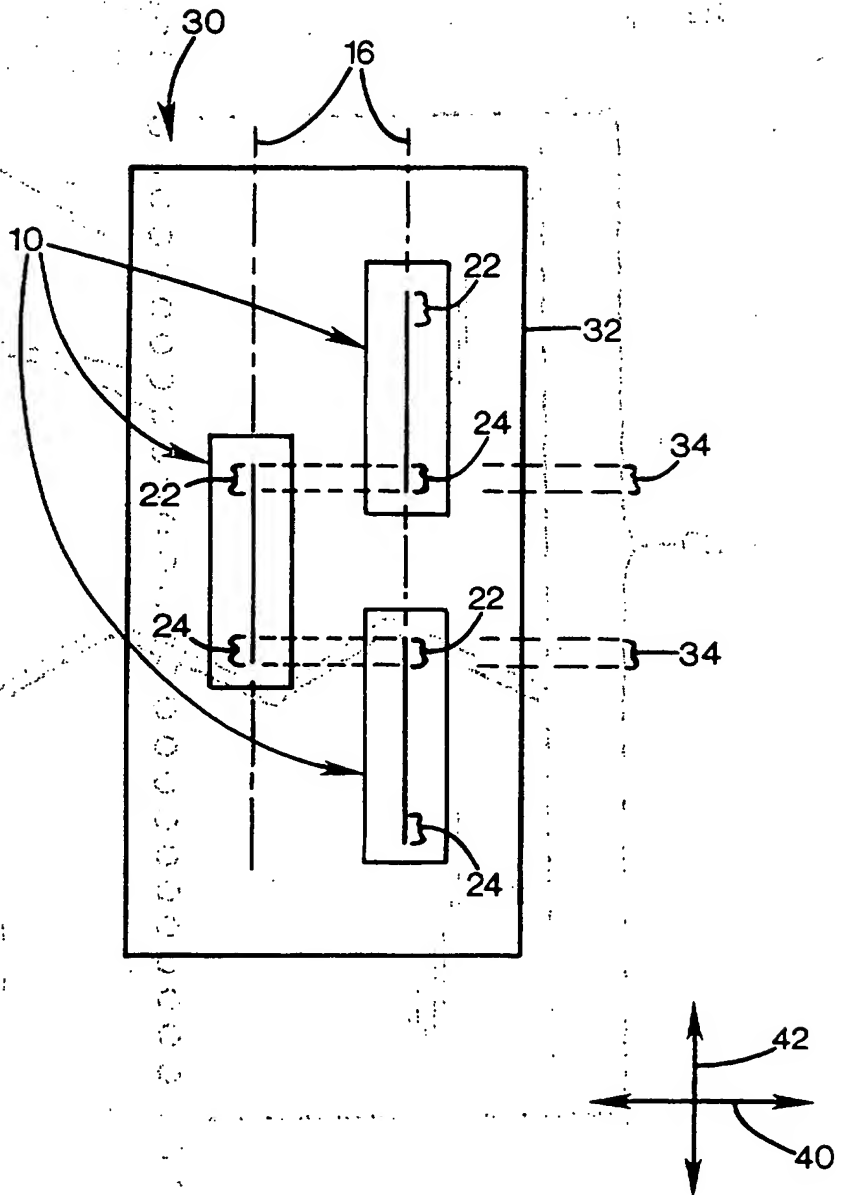


FIG. 3

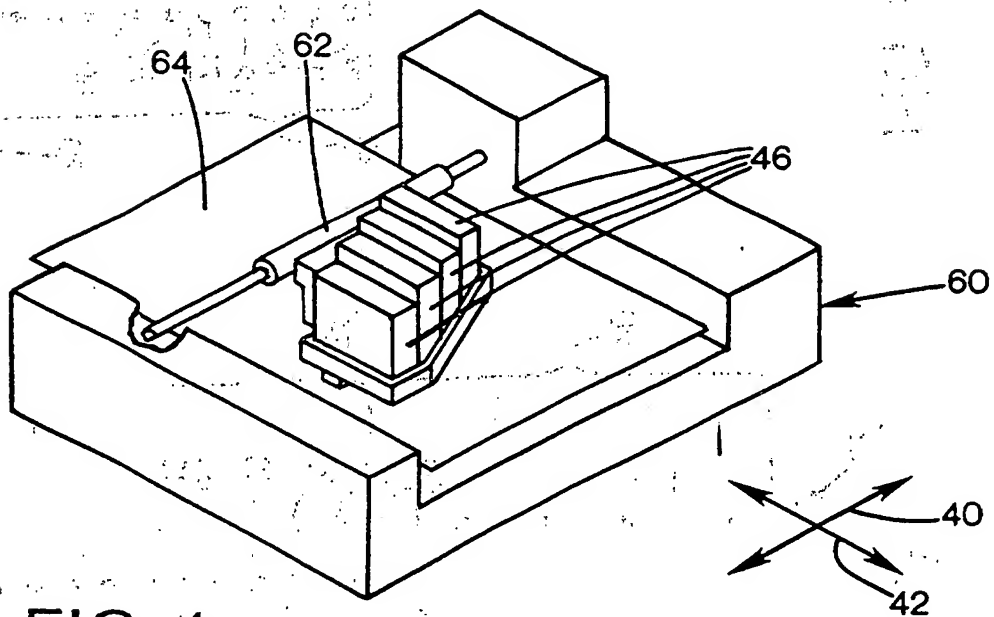
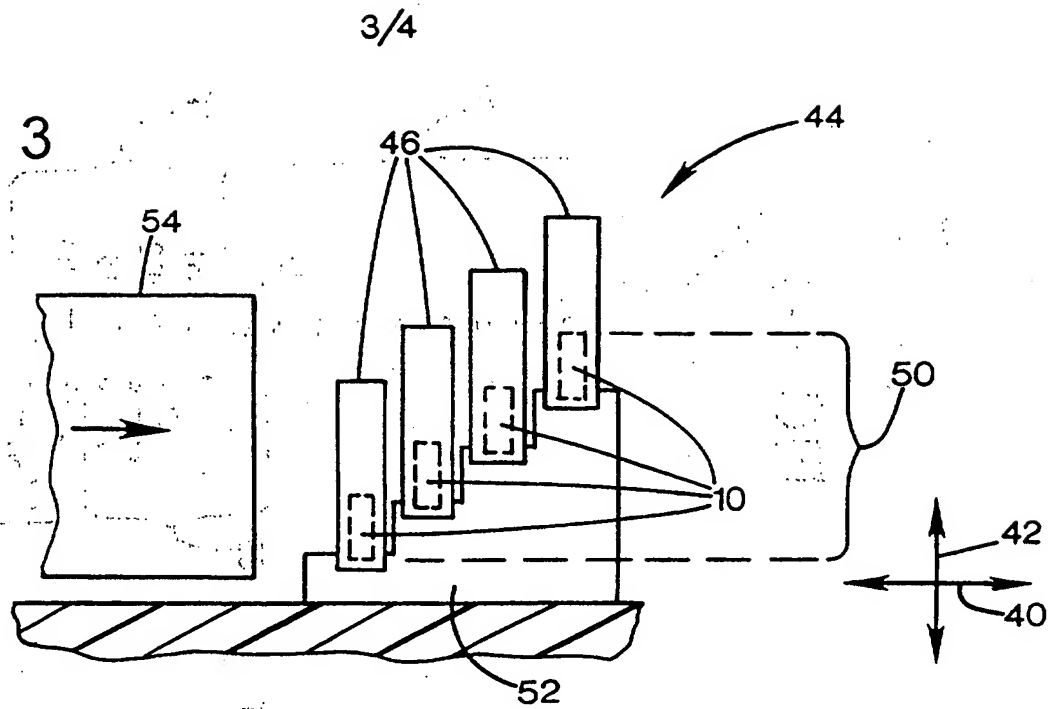


FIG. 4

FIG. 5C

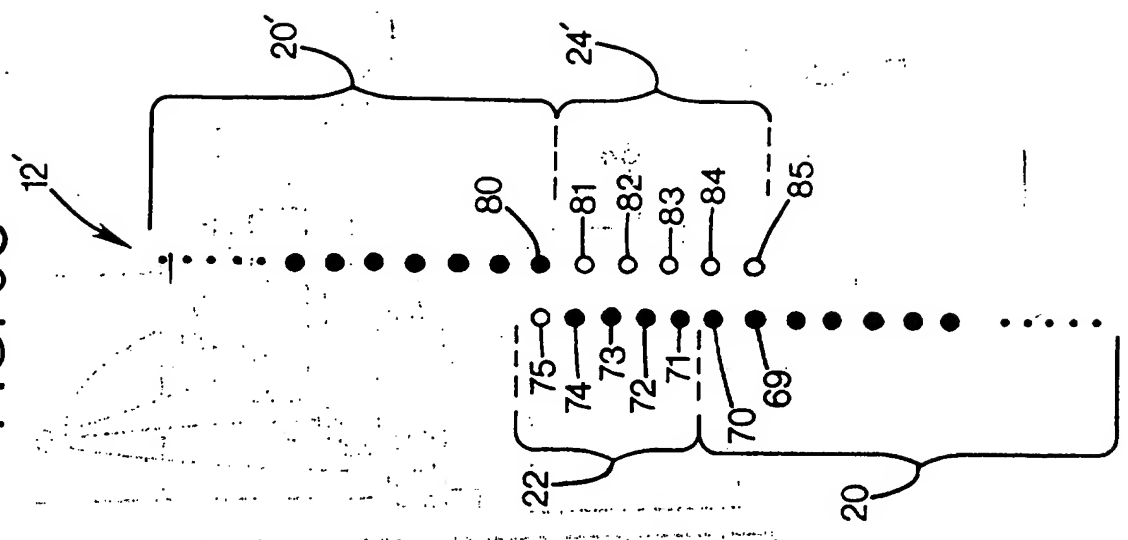


FIG. 5B

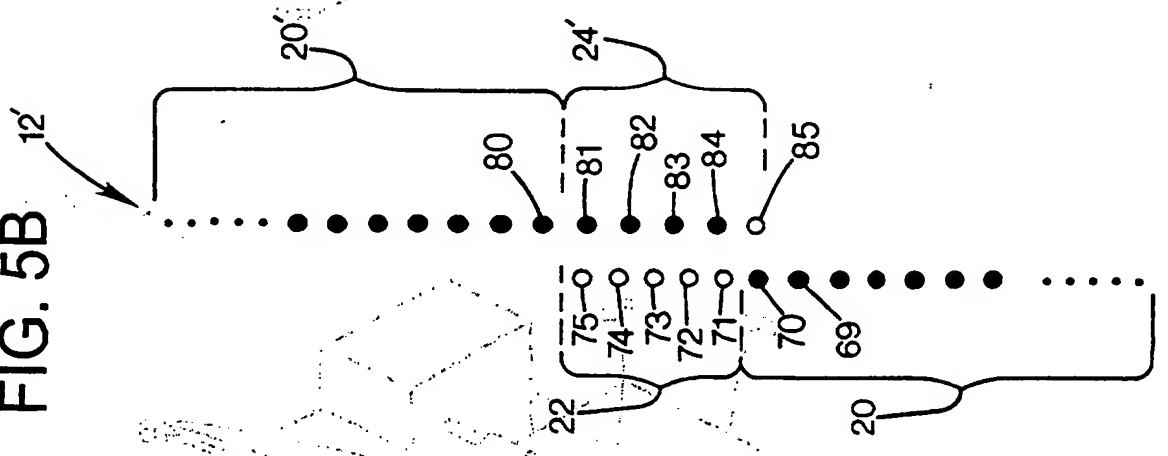
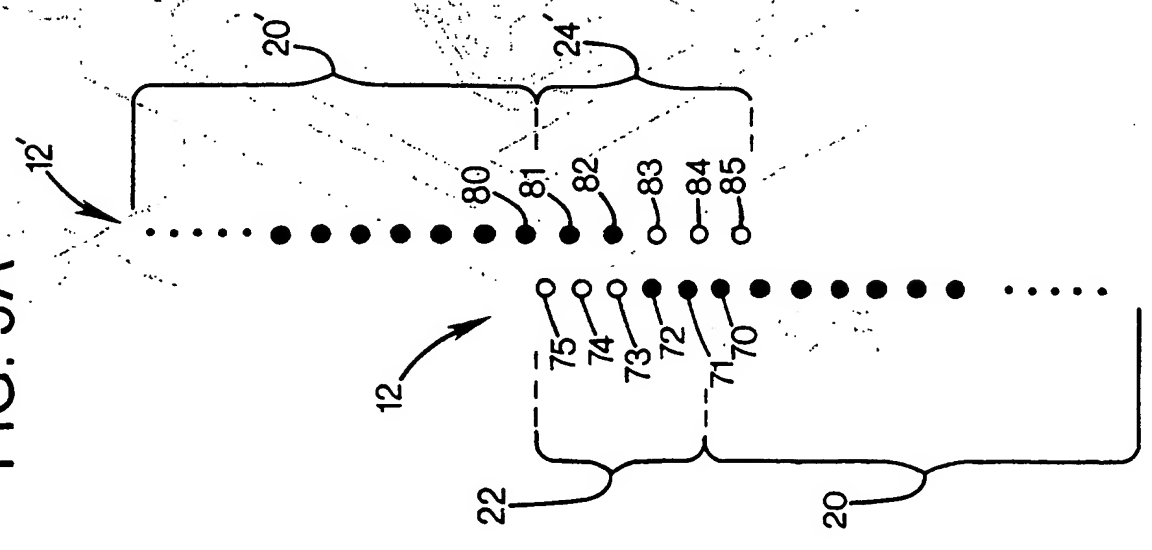


FIG. 5A



## INK JET PRINT HEAD WITH VARIED NOZZLE SPACING

### Field of the Invention

This invention relates to ink jet print heads, and more particularly to printers with multiple print heads.

### Background and Summary of the Invention

Ink jet printers employ pens having print heads that reciprocate relative to a media sheet and expel droplets through an array of nozzles onto the sheet to generate a printed image or pattern. The print heads have arrays of small orifices through which ink is expelled to generate a swath of a printed image.

Two important measures of printer performance are speed and print quality, which typically trade off with each other so that maximizing one compromises the other. The print speed is primarily limited by the scan velocity and by the length of the nozzle array (i.e. the width of a single printed swath). The print quality is primarily limited by the resolution or spacing of nozzles on the print head. For a given array length, the print quality may be maximized by printing multiple overlapping swaths to multiply the array's resolution, with the droplets of each swath filling the spaces between the droplets of other swaths. To maximize print speed, single passes are used.

Developments have led to higher resolution print heads that improve print quality without a speed compromise. However, these developments are limited by physical constraints on the miniaturization of print head components. To provide additional improvements in performance, larger print heads having longer arrays may be used.

However, as print heads are made larger, they become more expensive. Beyond the

proportional cost per unit area of semiconductor material, larger print head chips result in greater wafer edge losses, and other costs associated with larger chips. For instance, a single defect on a wafer ruins a larger percentage of that wafer's chips.

To avoid the costs associated with larger chips, a multiple chip print head may be employed, either with two or more print head chips of moderate size arranged on a common substrate, or with separate print heads installed in a printer. Such print heads are installed with their nozzle arrays parallel, and offset from each other along the media feed axis to cover adjacent swaths to generate a larger swath.

Such arrangements suffer from an alignment problem that can create a visible artifact where the adjacent swaths join each other at a seam. With high resolution print heads, a small misalignment at the limits of manufacturing capability can be several times the nozzle pitch, or at least a major fraction of the nozzle pitch. When separately replaceable print heads are used, the misalignment can be even greater. Electronic measures may permit correction of multiple-nozzle errors by slightly overlapping the swaths, and disabling the extra overlapping nozzles. However, this technique must tolerate an alignment error of up to one-half the nozzle pitch, leading to a possible gap or overlap of that amount. Such errors are visible as a light or dark band on the printed page.

The present invention overcomes the limitations of the prior art by providing an ink jet print head with a body defining an array of nozzles. The nozzles are arranged in an array along an array axis. The array has a first portion in which the nozzles are spaced apart along the array axis by a first pitch, and a second portion in which the nozzles are spaced apart by a different second pitch. The array may have a third portion at the opposite end from the second portion with a third pitch different from the first pitch. An assembly may include two or more of such print heads, with the second portion of one print head aligned with the third portion of the other print head. Such an assembly may be operated by determining an aligned pair of nozzles, and disabling the nozzles extending beyond each member of the pair and disabling one of the pair.

### Brief Description of the Drawings

Fig. 1 is an enlarged plan view of a ink jet print head die according to a preferred embodiment of the invention.

Fig. 2 is an enlarged plan view of a ink jet print head assembly according to the embodiment of Figure 1.

Fig. 3 is a simplified view of a printer according to an alternative embodiment of the invention.

Fig. 4 is a simplified view of a printer according to another alternative embodiment of the invention.

Figs. 5A, 5B, and 5C illustrate printing operation according to a preferred embodiment of the invention.

### Detailed Description of a Preferred Embodiment

Figure 1 shows an elongated rectangular ink jet print head die 10 defining a linear array 12 of nozzles or orifices 14 extending nearly the length of the chip, and oriented on an array axis 16. The array has a first central portion 20 in which the nozzles are evenly spaced apart along the array axis with a first pitch. A second end portion 22 of the array is contiguous with one end of the central portion, is oriented on the array axis, and includes several nozzles spaced apart at a second pitch incrementally smaller than the first pitch. A third end portion 24 of the array is contiguous with the opposite end of the central portion, is oriented on the array axis, and includes several nozzles spaced apart at a third pitch incrementally larger than the first pitch. Together, the end portions comprise a vernier system.

With a nozzle pitch or spacing period of  $t$ , and a total of  $N$  nozzles populating the end portions, the endmost  $N/2$  nozzles at one end are spaced at a pitch of  $t(1+1/N)$ , and the endmost  $N/2$  nozzles at the other end are spaced at a pitch of  $t(1-1/N)$ . For example, with a pitch of  $1/1200$  inch, and a 10-nozzle vernier system, the pitch of the five nozzles of the second portion 22 is  $(0.9/1200)$  inch, and the pitch of the five nozzles of the third portion 24 is  $(1.1/1200)$  inch.

As will be shown below, an arrangement of two such print head dies with overlapping end portions can provide a maximum apparent alignment error limited to  $t(1/N)$ , so that a



seam between swaths printed by the two dies will be essentially undetectable. The total alignment error that may be thus corrected or compensated for is limited to the number of vernier nozzles times the amount by which their pitch varies from the nominal pitch. In this instance, the number of nozzles  $N$  and the pitch variance ( $1/N$ ) are selected to provide a tolerated range of one full dot pitch. Within this range (which may be stated as  $\pm 1/2$  from a nominally aligned position) the maximum alignment error is limited as noted above, and as will be illustrated below. For systems in which wider alignment errors are expected, the total number of nozzles populating the end section or sections need not be increased, as these sections can overlap effectively with the nozzles of the central portion for the same vernier effect. Of course, for greater nominal overlap to accommodate large alignment

variances, slightly longer arrays are needed to provide a given final printed swath width. For systems in which less apparent alignment error is tolerable, a smaller pitch variance and proportionately more nozzles are used.

The illustrated embodiment shows a single linear array of nozzles for simplicity and clarity. In preferred practice, to provide a fine resolution, the nozzles of a single array are arranged in an alternating pattern of two parallel rows, with the odd nozzles in one row, and the even nozzles in the other, so that each row is closely spaced, and a doubled resolution is provided. For the purposes of this application, this arrangement of two or more such rows, or any other arrangement of nozzles along a print head intended to generate a swath of printed droplets, is considered as a single linear array.

Figure 2 shows a print head assembly 30 including three print head dies 10 arranged to generate a seamless swath of printing. In alternative embodiments, any number of dies from two or more may be used to provide a printed swath of any selected width. The dies 10 are arranged with their array axes 16 parallel. They are positioned in a common plane, mounted to a substrate 32, so that the end portion of one overlaps or is registered laterally with the end portion of the adjacent die in an overlap region 34. The assembly is oriented with the array axes 16 perpendicular to a scan axis 40 and parallel to a media feed axis 42, with the scan axis representing the path of motion of a reciprocating carriage in an ink jet printer as swaths are printed, and the feed axis representing the direction along which

printed media is advanced for printing of subsequent swaths. In an alternative embodiment, the assembly may be used in a printer in a fixed position, with media advancing along axis 40 for complete printing. This is suitable for rapid printing, such as of items passing on an assembly line, or postal envelopes to be addressed with a limited swath width. An assembly having a greater number of dies may be used to create swath widths capable of printing a page of unlimited width in a single swath, for extremely rapid printing throughput rates. The effective swath width of the assembly is slightly less than the sum total of all the individual arrays due to the overlapping end portions. Nominally, that sum is reduced by the overlap length 34 multiplied by the number of dies minus one.

10 As shown in Figures 3 and 4, a printer using multiple dies for a large swath width need not have the dies mounted on a single unit. Figure 3 shows a printer 44 having four separately replaceable print cartridges 46, each having one of the dies 10. The cartridges are positioned in a stepped arrangement to generate registration and overlapping of the end portions of each nozzle array with an end portion of each adjacent die. This generates a swath width 50. The cartridges are mounted in a fixed position to a base 52. A media sheet or other printable object 54 is advanced past the print heads along axis 40, which is perpendicular to the array axes. The process of compensating for any slight misalignments among print heads, both initially and after any print heads are replaced, will be discussed below.

20 Figure 4 shows an ink jet printer 60 having several staggered print cartridges 46 installed in a carriage 62 that reciprocates along the scan axis 42. A media sheet 64 is advanced along the feed axis following printing of each swath. The feed amount may be as great as the width of the swath for fastest printing, or may be a selected fraction of the swath width for optimum print quality printing using overlapping shingles. A printer having a carriage with multiple receptacles for the staggered print cartridge may also receive different colored cartridges for full color printing, albeit without the advantages of the increased swath width provided by several cartridges of the same color, typically black, and without enjoying the vernier alignment capabilities during color printing. Other alternatives may include assemblies for large swath printing of multiple colors, which simply use a multiple die array

for each of several different colors, all on the same assembly, or each color having its own multi-die wide-swath assembly on a separate cartridge. A set of multi-color dies may be used in the same manner as illustrated. Each die would have an array of each color, with each color array having vernier end portions aligning with comparable portions of the same color array on the next die.

Figures 5A, 5B, and 5C schematically illustrate the operation of a printing system using at least two print heads. The illustrations show which nozzles are operated in the overlapping end portions of the adjacent print heads, at three different variations in registration between the two print heads. This illustrates the transition or seaming between the swath portion printed by one array, and the portion printed by the adjacent array.

In Fig. 5A, a first nozzle array 12 has an end portion 22 that is laterally registered with the end portion 24' of a second array 12'. In this example, each end portion has five nozzles, with portion 22 spaced at 90% of the standard pitch, and end portion 24 spaced at 110% of the standard pitch. In this example, the second array 12' is nominally registered with the first, in that it is at the middle of the tolerance range in which the vernier system can maintain the tight tolerance ( $t/N$ ) on spacing between the last dot row printed by one array, and the first dot row printed by the next array.

The system operates in the manner of a vernier, with the different nozzle pitches providing one (or two adjacent) nozzles of one end portion approximately aligned with a nozzle (or pair) from the corresponding end portion of the other array. In this instance, nozzle 73 is best aligned with nozzle 82. The break point between swaths is selected to be at this aligned pair. This means that the nozzles of each end portion beyond the members of the aligned pair 73, 82 are to be disabled, with nozzles 74, 75, 83, 84, and 85 being disabled, preventing double printing overlap. One of the aligned pair also must be disabled to prevent double printing of a single dot row.

If the aligned pair is perfectly aligned, it does not matter which is disabled. However, in most instances such as this, the pair is slightly misaligned. When this occurs, a nozzle is disabled to ensure that one array is terminated by a member of the best aligned pair, and the other is terminated by a member of a second best aligned pair. The nozzles that are disabled

are indicated by open circles, and the nozzles that are enabled, by solid circles. In this case, it is apparent that the misalignment is in a direction such that pair 72-83 is the second best aligned pair, with pair 74-81 being less well aligned. Thus, selection of which of the

aligned pairs to disable is based on which one is a member of the array that contains a still enabled member of the second best aligned pair. Here, nozzle 72 of array 12 remains enabled, as it is positioned between the best aligned pair member 73 and the central portion 20 of the array. Second best aligned pair member 83, however, is already disabled, as it is beyond the best aligned member 82. Thus, nozzle 73 is disabled, so that array 12 is terminated by an operable nozzle of the second best aligned pair, and array 12' is terminated by a member of the best aligned pair.

Figure 5B illustrates the same system, but with the array 12' shifted upward for a reduced overlap condition. This approximates nearly the limit at which the ability to maintain limited seam alignment errors is compromised. In this instance, nozzle 70 appears well aligned with nozzle 85. Thus either may be disabled. However, it is preferable to disable a remote or end nozzle such as 85, instead of a member of the center array portion. It is believed that nozzles nearer the end of an array may have a slightly higher failure rate, so that some nominal reliability advantage may be gained with this preference.

Accordingly, along with nozzles 71-75, nozzle 85 is disabled. This rule may also be applied in other instances where there is an equal choice between two well aligned nozzles, not just a choice involving an end nozzle. Note that if the array 12' were shifted upward enough to slightly misalign the pair 70-85 (i.e. by up to 1/10 of a nozzle pitch), nozzle 85 would remain enabled, and nozzle 70 disabled, as nozzle 96 and imaginary nozzle 86 (not shown) would be a second best aligned pair.

Figure 5C illustrates a greater overlap condition, in which pair 75-80 is best aligned, and nozzle 75 disabled on the principle of disabling a remote nozzle when alignment is ideal.

As above, a slightly more extreme misalignment between the arrays (by moving array 12' downward by a small fraction of a nozzle pitch) would necessitate the disabling of nozzle 75 instead, under the higher order rule that the array with a disabled best-aligned nozzle shall have its second best aligned nozzle as the terminal enabled nozzle. As noted above,

the system can tolerate any amount of overlap while maintaining the accurate alignment at the seam, due to the ability for either of the end portions to operate as a vernier against the central portion of the next array.

The process of determining which nozzles are aligned depends on the application. After manufacture of a print head assembly 30 as in Figure 2, the assembled unit can be inspected to determine alignment and disabling choices. This may be undertaken by an automated system using microscopic machine vision, which transmits disablement data to control circuitry (not shown) on the die, assembly, printer, or connected computer. Another means of determining alignment is to print a test pattern, which may selectively print lines to aid a visual or machine detected alignment. Such printed patterns may also employ moiré patterns to aid the recognition of fine misalignments. These may also be used in systems in which the print heads are separately replaceable in the field. In these cases, a user or service technician runs an alignment test, typically with the aid of alignment software in a computer connected to the printer in which the print heads are installed. The software prints patterns, and inquires as to which of selected samples exhibits a visual characteristic associated with alignment. The user enters the preference, and the computer then instructs the printer control circuitry to disable appropriate nozzles. Similarly, a sensor in the printer may automatically scan an alignment pattern, and transmit alignment information to the control circuitry without user involvement or the opportunity for operator error.

While the above is discussed in terms of preferred and alternative embodiments, the invention is not intended to be so limited. For instance, the number of end portion nozzles and pitch differences can vary widely depending on the sensitivity to misalignment. In an alternative embodiment, a spacing variation need be provided at only one end of the array. This would operate as a vernier against the standard spacing. The equivalent of the illustrated example might be provided by five nozzles at one end, with 120% or 80% of the standard spacing, to provide the  $t/10$  accuracy. However, this may make the end portion more noticeably dense or light in appearance in the printed result. In this case, as in the preferred embodiment, such density variations are compensated for by designing the print head to emit proportionately larger droplets from more widely spaced end portion nozzles,

and proportionately smaller droplets from densified end portions, generating comparable visual print density.

The illustrated system may also be employed as a single print head, with the varied spacing end portions used to provide better seaming between sequentially-printed swaths.

- 5 A printer design with a media advance amount that varies from printer to printer, but which is precisely repeated within each printer, is a suitable application. Each printer's advance amount may be measured, and the selection of which end portion nozzles made to ensure accurate seaming between swaths, using the techniques of the preferred embodiment.

## Claims:

1. An ink jet print head (10) comprising:
  - a body defining an array (12) of nozzles (14);
  - the nozzles being arranged in an array along an array axis (16);
  - the array having a first portion (22) in which the nozzles are spaced apart along the array axis by a first pitch; and
  - the array having a second portion (24) in which the nozzles are spaced apart by a different second pitch.
2. An ink jet print head according to claim 1 wherein the first and second portions (22, 24) include nozzles at opposed ends of the array.
3. An ink jet print head according to claim 1 or claim 2 including a third portion (20) having a third pitch different from the first pitch and the second pitch.
4. An ink jet print head according to any one of claims 1 to 3 wherein the first and second portions have approximately the same length.
5. An ink jet print head according to any one of claims 1 to 4 wherein the difference between the second pitch and the first pitch, multiplied by the number of nozzles occupying the first and second portions, is at least as great as the lesser of the nozzle pitches.
6. A method of operating an ink jet printer (60) comprising the steps:
  - providing at least a first print head (10) and a second print head (10), each defining an array of apertures (14) parallel to a common array axis (16), the arrays each having an overlapping portion (22, 24) and a major portion (20), the overlapping portions registered with each other, the major portions of each array extending away from the associated overlapping portion, the overlapping portions each having a different nozzle pitch;
  - determining a best aligned pair of nozzles (72, 83), one nozzle of the pair selected

from the overlapping portions of each of the arrays;

for each overlapping portion, disabling the nozzles (73, 74, 75, 83, 84, 85) of an  
extending portion extending away from the major portion beyond the nozzle of the  
aligned pair; and

5        disabling one of the nozzles (83) of the aligned pair.

7. A method of operating an ink jet printer according to claim 6 including operating the  
printer (60) to print using the remaining nozzles other than the disabled nozzles.
8. A method of operating an ink jet printer according to claim 6 or claim 7 wherein  
determining a best aligned pair of nozzles includes printing a test pattern (12, 12').
- 10    9. A method of operating an ink jet printer according to any one of claims 6 to 8 including  
operating the printer to emit a different drop volume through at least some of the  
nozzles (14) of at least one of the overlapping portion from the drop volume emitted  
through the nozzles of the major portions.
- 15    10. A method of operating an ink jet printer according to any one of claims 6 to 9 including  
operating the printer to emit a drop volume through each nozzle (14) based on the pitch  
of the portion in which each nozzle resides.





INVESTOR IN PEOPLE

Application No: GB 0018992.8  
Claims searched: 1-10

12  
Examiner: Gary Williams  
Date of search: 21 December 2000

**Patents Act 1977**  
**Search Report under Section 17**

**Databases searched:**

UK Patent Office collections, including GB, EP, WO & US patent specifications, in:

UK Cl (Ed.R): B6F:FLM

Int Cl (Ed.7): B41J: 2/145,2/15

Other: Online:EPODOC,PAJ,WPI

**Documents considered to be relevant:**

Category	Identity of document and relevant passage	Relevant to claims
X	EP 0481829 A2 (HEWLETT-PACKARD) See Fig.2, col.6 line 29 - col.7 line 14	1
A	US 5764254 (HEWLETT-PACKARD) See Figs.8,13C, col.4 lines 45-53, col.6 lines 1-14	6
X	US 5598191 (XEROX) See Fig.2, col.5 lines 5-36	1
X	US 5075689 (SPECTRA) See Fig.4, col.6 line 24 - col.7 line 5	1,2
X	US 4215350 (MIELKE) See Fig.2, col.2 lines 55-65	1,2

X Document indicating lack of novelty or inventive step  
Y Document indicating lack of inventive step if combined with one or more other documents of same category.  
& Member of the same patent family

A Document indicating technological background and/or state of the art.  
P Document published on or after the declared priority date but before the filing date of this invention.  
E Patent document published on or after, but with priority date earlier than, the filing date of this application.

[illegible]

2000, 2001, 2002, 2003, 2004, 2005, 2006, 2007, 2008, 2009, 2010, 2011, 2012, 2013, 2014, 2015, 2016, 2017, 2018, 2019, 2020, 2021, 2022, 2023, 2024, 2025, 2026, 2027, 2028, 2029, 2030, 2031, 2032, 2033, 2034, 2035, 2036, 2037, 2038, 2039, 2040, 2041, 2042, 2043, 2044, 2045, 2046, 2047, 2048, 2049, 2050, 2051, 2052, 2053, 2054, 2055, 2056, 2057, 2058, 2059, 2060, 2061, 2062, 2063, 2064, 2065, 2066, 2067, 2068, 2069, 2070, 2071, 2072, 2073, 2074, 2075, 2076, 2077, 2078, 2079, 2080, 2081, 2082, 2083, 2084, 2085, 2086, 2087, 2088, 2089, 2090, 2091, 2092, 2093, 2094, 2095, 2096, 2097, 2098, 2099, 2100, 2101, 2102, 2103, 2104, 2105, 2106, 2107, 2108, 2109, 2110, 2111, 2112, 2113, 2114, 2115, 2116, 2117, 2118, 2119, 2120, 2121, 2122, 2123, 2124, 2125, 2126, 2127, 2128, 2129, 2130, 2131, 2132, 2133, 2134, 2135, 2136, 2137, 2138, 2139, 2140, 2141, 2142, 2143, 2144, 2145, 2146, 2147, 2148, 2149, 2150, 2151, 2152, 2153, 2154, 2155, 2156, 2157, 2158, 2159, 2160, 2161, 2162, 2163, 2164, 2165, 2166, 2167, 2168, 2169, 2170, 2171, 2172, 2173, 2174, 2175, 2176, 2177, 2178, 2179, 2180, 2181, 2182, 2183, 2184, 2185, 2186, 2187, 2188, 2189, 2190, 2191, 2192, 2193, 2194, 2195, 2196, 2197, 2198, 2199, 2200, 2201, 2202, 2203, 2204, 2205, 2206, 2207, 2208, 2209, 2210, 2211, 2212, 2213, 2214, 2215, 2216, 2217, 2218, 2219, 2220, 2221, 2222, 2223, 2224, 2225, 2226, 2227, 2228, 2229, 2230, 2231, 2232, 2233, 2234, 2235, 2236, 2237, 2238, 2239, 2240, 2241, 2242, 2243, 2244, 2245, 2246, 2247, 2248, 2249, 2250, 2251, 2252, 2253, 2254, 2255, 2256, 2257, 2258, 2259, 2260, 2261, 2262, 2263, 2264, 2265, 2266, 2267, 2268, 2269, 2270, 2271, 2272, 2273, 2274, 2275, 2276, 2277, 2278, 2279, 2280, 2281, 2282, 2283, 2284, 2285, 2286, 2287, 2288, 2289, 2290, 2291, 2292, 2293, 2294, 2295, 2296, 2297, 2298, 2299, 2300, 2301, 2302, 2303, 2304, 2305, 2306, 2307, 2308, 2309, 2310, 2311, 2312, 2313, 2314, 2315, 2316, 2317, 2318, 2319, 2320, 2321, 2322, 2323, 2324, 2325, 2326, 2327, 2328, 2329, 2330, 2331, 2332, 2333, 2334, 2335, 2336, 2337, 2338, 2339, 2340, 2341, 2342, 2343, 2344, 2345, 2346, 2347, 2348, 2349, 2350, 2351, 2352, 2353, 2354, 2355, 2356, 2357, 2358, 2359, 2360, 2361, 2362, 2363, 2364, 2365, 2366, 2367, 2368, 2369, 2370, 2371, 2372, 2373, 2374, 2375, 2376, 2377, 2378, 2379, 2380, 2381, 2382, 2383, 2384, 2385, 2386, 2387, 2388, 2389, 2390, 2391, 2392, 2393, 2394, 2395, 2396, 2397, 2398, 2399, 2400, 2401, 2402, 2403, 2404, 2405, 2406, 2407, 2408, 2409, 2410, 2411, 2412, 2413, 2414, 2415, 2416, 2417, 2418, 2419, 2420, 2421, 2422, 2423, 2424, 2425, 2426, 2427, 2428, 2429, 2430, 2431, 2432, 2433, 2434, 2435, 2436, 2437, 2438, 2439, 2440, 2441, 2442, 2443, 2444, 2445, 2446, 2447, 2448, 2449, 2450, 2451, 2452, 2453, 2454, 2455, 2456, 2457, 2458, 2459, 2460, 2461, 2462, 2463, 2464, 2465, 2466, 2467, 2468, 2469, 2470, 2471, 2472, 2473, 2474, 2475, 2476, 2477, 2478, 2479, 2480, 2481, 2482, 2483, 2484, 2485, 2486, 2487, 2488, 2489, 2490, 2491, 2492, 2493, 2494, 2495, 2496, 2497, 2498, 2499, 2500, 2501, 2502, 2503, 2504, 2505, 2506, 2507, 2508, 2509, 2510, 2511, 2512, 2513, 2514, 2515, 2516, 2517, 2518, 2519, 2520, 2521, 2522, 2523, 2524, 2525, 2526, 2527, 2528, 2529, 2530, 2531, 2532, 2533, 2534, 2535, 2536, 2537, 2538, 2539, 2540, 2541, 2542, 2543, 2544, 2545, 2546, 2547, 2548, 2549, 2550, 2551, 2552, 2553, 2554, 2555, 2556, 2557, 2558, 2559, 2560, 2561, 2562, 2563, 2564, 2565, 2566, 2567, 2568, 2569, 2570, 2571, 2572, 2573, 2574, 2575, 2576, 2577, 2578, 2579, 2580, 2581, 2582, 2583, 2584, 2585, 2586, 2587, 2588, 2589, 2590, 2591, 2592, 2593, 2594, 2595, 2596, 2597, 2598, 2599, 2600, 2601, 2602, 2603, 2604, 2605, 2606, 2607, 2608, 2609, 2610, 2611, 2612, 2613, 2614, 2615, 2616, 2617, 2618, 2619, 2620, 2621, 2622, 2623, 2624, 2625, 2626, 2627, 2628, 2629, 2630, 2631, 2632, 2633, 2634, 2635, 2636, 2637, 2638, 2639, 2640, 2641, 2642, 2643, 2644, 2645, 2646, 2647, 2648, 2649, 2650, 2651, 2652, 2653, 2654, 2655, 2656, 2657, 2658, 2659, 2660, 2661, 2662, 2663, 2664, 2665, 2666, 2667, 2668, 2669, 2670, 2671, 2672, 2673, 2674, 2675, 2676, 2677, 2678, 2679, 2680, 2681, 26

... ..

3. APPROXIMATE RELEASE DATE: 1964

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

1997年12月  
 1998年1月  
 1998年2月  
 1998年3月  
 1998年4月  
 1998年5月  
 1998年6月  
 1998年7月  
 1998年8月  
 1998年9月  
 1998年10月  
 1998年11月  
 1998年12月  
 1999年1月  
 1999年2月  
 1999年3月  
 1999年4月  
 1999年5月  
 1999年6月  
 1999年7月  
 1999年8月  
 1999年9月  
 1999年10月  
 1999年11月  
 1999年12月  
 2000年1月  
 2000年2月  
 2000年3月  
 2000年4月  
 2000年5月  
 2000年6月  
 2000年7月  
 2000年8月  
 2000年9月  
 2000年10月  
 2000年11月  
 2000年12月  
 2001年1月  
 2001年2月  
 2001年3月  
 2001年4月  
 2001年5月  
 2001年6月  
 2001年7月  
 2001年8月  
 2001年9月  
 2001年10月  
 2001年11月  
 2001年12月  
 2002年1月  
 2002年2月  
 2002年3月  
 2002年4月  
 2002年5月  
 2002年6月  
 2002年7月  
 2002年8月  
 2002年9月  
 2002年10月  
 2002年11月  
 2002年12月  
 2003年1月  
 2003年2月  
 2003年3月  
 2003年4月  
 2003年5月  
 2003年6月  
 2003年7月  
 2003年8月  
 2003年9月  
 2003年10月  
 2003年11月  
 2003年12月  
 2004年1月  
 2004年2月  
 2004年3月  
 2004年4月  
 2004年5月  
 2004年6月  
 2004年7月  
 2004年8月  
 2004年9月  
 2004年10月  
 2004年11月  
 2004年12月  
 2005年1月  
 2005年2月  
 2005年3月  
 2005年4月  
 2005年5月  
 2005年6月  
 2005年7月  
 2005年8月  
 2005年9月  
 2005年10月  
 2005年11月  
 2005年12月  
 2006年1月  
 2006年2月  
 2006年3月  
 2006年4月  
 2006年5月  
 2006年6月  
 2006年7月  
 2006年8月  
 2006年9月  
 2006年10月  
 2006年11月  
 2006年12月  
 2007年1月  
 2007年2月  
 2007年3月  
 2007年4月  
 2007年5月  
 2007年6月  
 2007年7月  
 2007年8月  
 2007年9月  
 2007年10月  
 2007年11月  
 2007年12月  
 2008年1月  
 2008年2月  
 2008年3月  
 2008年4月  
 2008年5月  
 2008年6月  
 2008年7月  
 2008年8月  
 2008年9月  
 2008年10月  
 2008年11月  
 2008年12月  
 2009年1月  
 2009年2月  
 2009年3月  
 2009年4月  
 2009年5月  
 2009年6月  
 2009年7月  
 2009年8月  
 2009年9月  
 2009年10月  
 2009年11月  
 2009年12月  
 2010年1月  
 2010年2月  
 2010年3月  
 2010年4月  
 2010年5月  
 2010年6月  
 2010年7月  
 2010年8月  
 2010年9月  
 2010年10月  
 2010年11月  
 2010年12月  
 2011年1月  
 2011年2月  
 2011年3月  
 2011年4月  
 2011年5月  
 2011年6月  
 2011年7月  
 2011年8月  
 2011年9月  
 2011年10月  
 2011年11月  
 2011年12月  
 2012年1月  
 2012年2月  
 2012年3月  
 2012年4月  
 2012年5月  
 2012年6月  
 2012年7月  
 2012年8月  
 2012年9月  
 2012年10月  
 2012年11月  
 2012年12月  
 2013年1月  
 2013年2月  
 2013年3月  
 2013年4月  
 2013年5月  
 2013年6月  
 2013年7月  
 2013年8月  
 2013年9月  
 2013年10月  
 2013年11月  
 2013年12月  
 2014年1月  
 2014年2月  
 2014年3月  
 2014年4月  
 2014年5月  
 2014年6月  
 2014年7月  
 2014年8月  
 2014年9月  
 2014年10月  
 2014年11月  
 2014年12月  
 2015年1月  
 2015年2月  
 2015年3月  
 2015年4月  
 2015年5月  
 2015年6月  
 2015年7月  
 2015年8月  
 2015年9月  
 2015年10月  
 2015年11月  
 2015年12月  
 2016年1月  
 2016年2月  
 2016年3月  
 2016年4月  
 2016年5月  
 2016年6月  
 2016年7月  
 2016年8月  
 2016年9月  
 2016年10月  
 2016年11月  
 2016年12月  
 2017年1月  
 2017年2月  
 2017年3月  
 2017年4月  
 2017年5月  
 2017年6月  
 2017年7月  
 2017年8月  
 2017年9月  
 2017年10月  
 2017年11月  
 2017年12月  
 2018年1月  
 2018年2月  
 2018年3月  
 2018年4月  
 2018年5月  
 2018年6月  
 2018年7月  
 2018年8月  
 2018年9月  
 2018年10月  
 2018年11月  
 2018年12月  
 2019年1月  
 2019年2月  
 2019年3月  
 2019年4月  
 2019年5月  
 2019年6月  
 2019年7月  
 2019年8月  
 2019年9月  
 2019年10月  
 2019年11月  
 2019年12月  
 2020年1月  
 2020年2月  
 2020年3月  
 2020年4月  
 2020年5月  
 2020年6月  
 2020年7月  
 2020年8月  
 2020年9月  
 2020年10月  
 2020年11月  
 2020年12月  
 2021年1月  
 2021年2月  
 2021年3月  
 2021年4月  
 2021年5月  
 2021年6月  
 2021年7月  
 2021年8月  
 2021年9月  
 2021年10月  
 2021年11月  
 2021年12月  
 2022年1月  
 2022年2月  
 2022年3月  
 2022年4月  
 2022年5月  
 2022年6月  
 2022年7月  
 2022年8月  
 2022年9月  
 2022年10月  
 2022年11月  
 2022年12月  
 2023年1月  
 2023年2月  
 2023年3月  
 2023年4月  
 2023年5月  
 2023年6月  
 2023年7月  
 2023年8月  
 2023年9月  
 2023年10月  
 2023年11月  
 2023年12月  
 2024年1月  
 2024年2月  
 2024年3月  
 2024年4月  
 2024年5月  
 2024年6月  
 2024年7月  
 2024年8月  
 2024年9月  
 2024年10月  
 2024年11月  
 2024年12月  
 2025年1月  
 2025年2月  
 2025年3月  
 2025年4月  
 2025年5月  
 2025年6月  
 2025年7月  
 2025年8月  
 2025年9月  
 2

the 1990s, the number of people in the United States who are 65 years of age or older is projected to increase from 20 million to 30 million, and the number of people 75 years of age or older is projected to increase from 10 million to 15 million (U.S. Census Bureau, 1996). The number of people 85 years of age or older is projected to increase from 2 million to 4 million (U.S. Census Bureau, 1996). The number of people 90 years of age or older is projected to increase from 500,000 to 1 million (U.S. Census Bureau, 1996). The number of people 95 years of age or older is projected to increase from 100,000 to 200,000 (U.S. Census Bureau, 1996). The number of people 100 years of age or older is projected to increase from 10,000 to 20,000 (U.S. Census Bureau, 1996).

**THIS PAGE BLANK (USPTO)**

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

And, finally, the *Journal of Management Studies* is a journal of management studies, not of management education. The journal is not a forum for the discussion of management education, but a forum for the discussion of management studies. The journal is not a forum for the discussion of management education, but a forum for the discussion of management studies.

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

the 1990s, the number of people in the United States who are 65 years of age or older is projected to increase from 20 million to 35 million, and the number of people 75 years of age or older is projected to increase from 10 million to 15 million (U.S. Census Bureau, 1996). The number of people 85 years of age or older is projected to increase from 2 million to 4 million (U.S. Census Bureau, 1996). The number of people 90 years of age or older is projected to increase from 500,000 to 1 million (U.S. Census Bureau, 1996). The number of people 95 years of age or older is projected to increase from 100,000 to 200,000 (U.S. Census Bureau, 1996). The number of people 100 years of age or older is projected to increase from 10,000 to 20,000 (U.S. Census Bureau, 1996).

*Journal of Management Education* 30(6)p.789-804  
© The Author(s) 2006. Reprints and permissions:  
<http://www.sagepub.com/journalsPermissions.nav>

the 1990s, the number of people in the United States who are 65 years of age or older is projected to increase from 20 million to 35 million, and the number of people 75 years of age or older is projected to increase from 10 million to 15 million (U.S. Census Bureau, 1996). The number of people 85 years of age or older is projected to increase from 2 million to 4 million (U.S. Census Bureau, 1996). The number of people 90 years of age or older is projected to increase from 500,000 to 1 million (U.S. Census Bureau, 1996). The number of people 95 years of age or older is projected to increase from 100,000 to 200,000 (U.S. Census Bureau, 1996). The number of people 100 years of age or older is projected to increase from 10,000 to 20,000 (U.S. Census Bureau, 1996).

**THIS PAGE BLANK (USPTO)**